

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-028786**Date Inspected:** 06-Nov-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 800**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** CK Johnson**Location:** Arcata, CA

CWI Name:	Ralph Worley		
Inspected CWI report:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A

CWI Present:	Yes	No
Rod Oven in Use:	Yes	No N/A
Weld Procedures Followed:	Yes	No N/A
Verified Joint Fit-up:	Yes	No N/A
Approved WPS:	Yes	No N/A
Delayed / Cancelled:	Yes	No N/A

Bridge No: 34-0006**Component:** PWS Cable System Seals**Summary of Items Observed:**

On this date Caltrans Quality Assurance (QA) Inspector, Scott A Leavitt, arrived at C&K Johnson Industries, in Arcata, CA and met with Ralph Woley, C&K Johnson Industries, Quality Control Inspector. The purpose of the visit was to witness in-process welding of cable seal mounts and shrouds.

Observed the following work in progress: FCAW fillet and CJP welds on seal mount quarters, butt welds and flanges. Welders are identified as Bret Holmgren (H-2), John Amis (A-1), Randy Buhler (B-4), Jason Garza (G-1), Jacob Garza (G-4) and Jeff Brazil (B-4) all of whom had submitted welder qualifications in the WQPC. Welders were welding to WPS 1-1-M-FC-6-U-825 for the butt welds and WPS 1-1-M-FC-6-F-825 for the fillet welds. Performed a random check of electrical parameters for shop WPS 1-1-m-FC-6-U-825 at the work station of John Amis. Mr Amis was welding in the 1G (flat position) and QA noted 200 amps, 28.5 volts, which were within the stated parameters of the WPS.

The above identified inspection and report was performed and written by Caltrans QA Inspector Scott Leavitt and submitted by Caltrans QA Richard Bettencourt

Summary of Conversations:

No pertinent conversation.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas, (916) 764-6027, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By: Bettencourt,Rick

Quality Assurance Inspector

Reviewed By: Foerder,Mike

QA Reviewer